

Date: Monday, 2/4/2008 11:25:49 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: INLET VALVE SHAFT
Job Number	: 37173		
Estimate Number	: 12249		
P.O. Number	:	Part Number	: D34741
This Issue	: 2/4/2008 S.O. No. :	Drawing Number	: D3474 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 35161	Material	:
Written By	:	Due Date	: 2/28/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>08 02 04</u>		
Comment	: est rev. A 06.04.20 New issue EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M303R0250 303 Round Bar 0.250"



Comment: Qty.: 0.3171 f(s)/Unit Total : 1.2684 f(s)

AISI 303 Round Bar 0.250" batch: 07129

08/02/19

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blank 3.65 " long

08/02/19

3.0 LATHE CONV. CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE

1-Turn chamfer and face ends as per dwg D3474

08/02/19

4.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- Mill as per dwg D3474

2-Deburr as per dwg D3474

08/02/19

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 101

8/2/19

50

7x

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 08/02/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 2/4/2008 11:25:49 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INLET VALVE SHAFT

Job Number: 37173

Part Number: D34741

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/20

Job Completion



2008/2/20 (7)

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

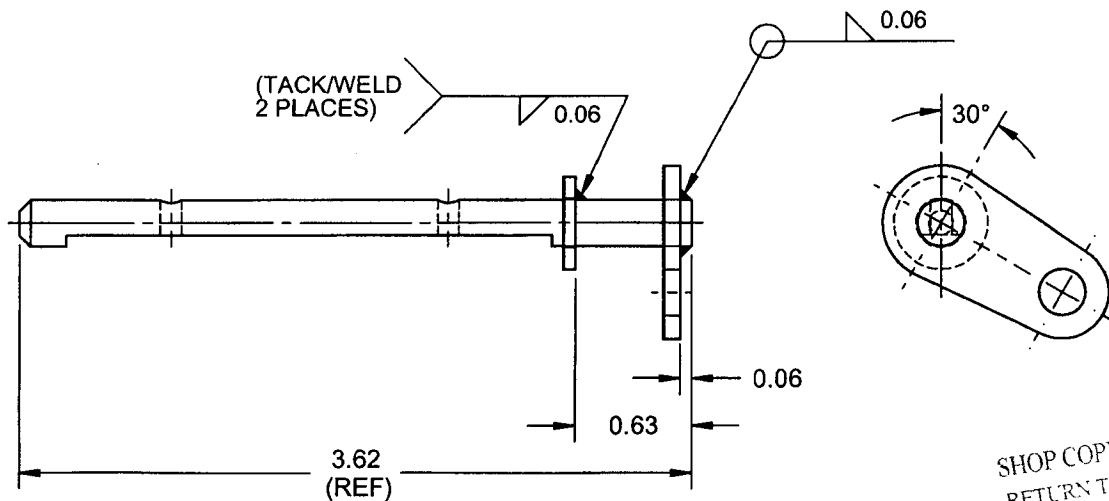
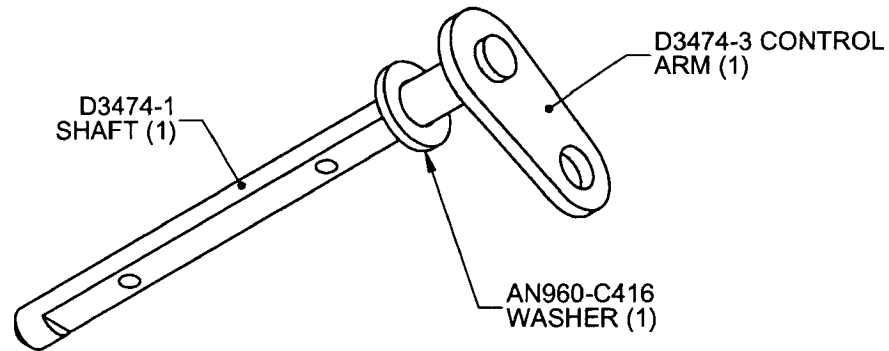
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3474</b>	REV. A SHEET 1 OF 4
DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1
A	06.01.23	NEW ISSUE	

*[Handwritten]* 06.04.03**D3474-041 INLET VALVE SHAFT**

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. **37173**

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

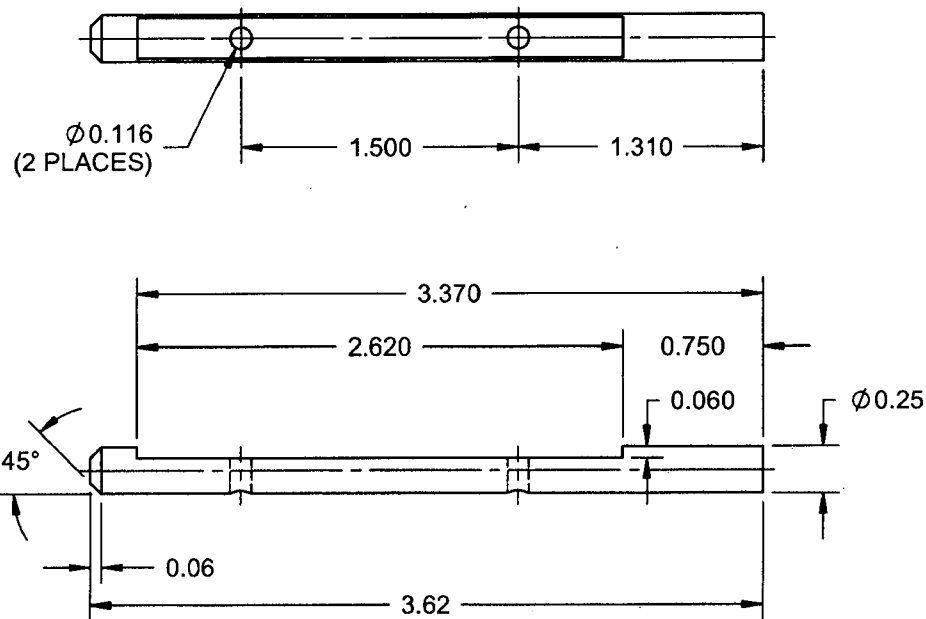
QTY -041	P/N	DESCRIPTION
X	D3474-041	INLET VALVE SHAFT
1	D3474-1	SHAFT
1	D3474-3	CONTROL ARM
1	AN960-C416	WASHER

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DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1

*[Signature]* 06-04-03**D3474-1 SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR  
(REF. DART SPEC. M303R0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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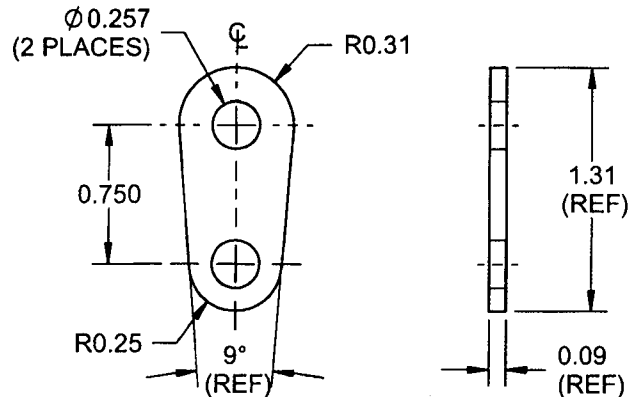
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DATE <b>06.01.23</b>	TITLE <b>INLET VALVE SHAFT</b>		SCALE 1:1

*06.04.03*

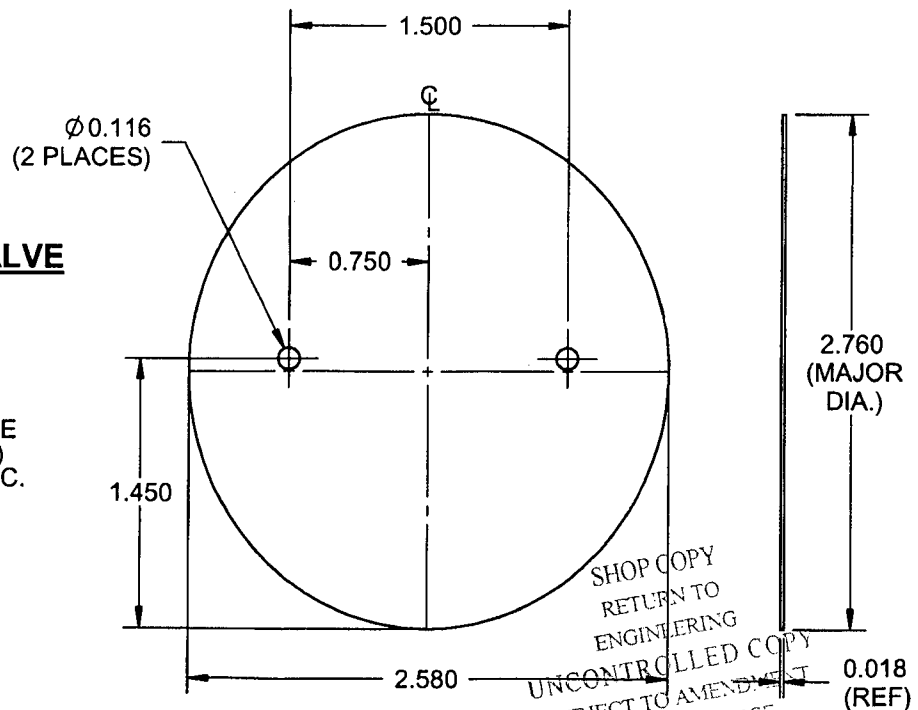
### **D3474-3 CONTROL ARM FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 SS SHEET PER  
MIL-S-5019 (ANNEALED) 2B  
FINISH 13 GAUGE SS  
(0.090 THICK)  
(REF. DART SPEC. M304S13GA)



### **D3474-5 BUTTERFLY VALVE FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 SS  
SHEET PER  
MIL-S-5019  
(ANNEALED) 2B  
FINISH 26 GAUGE  
SS (0.018 THICK)  
(REF. DART SPEC.  
M304S26GA)



#### **NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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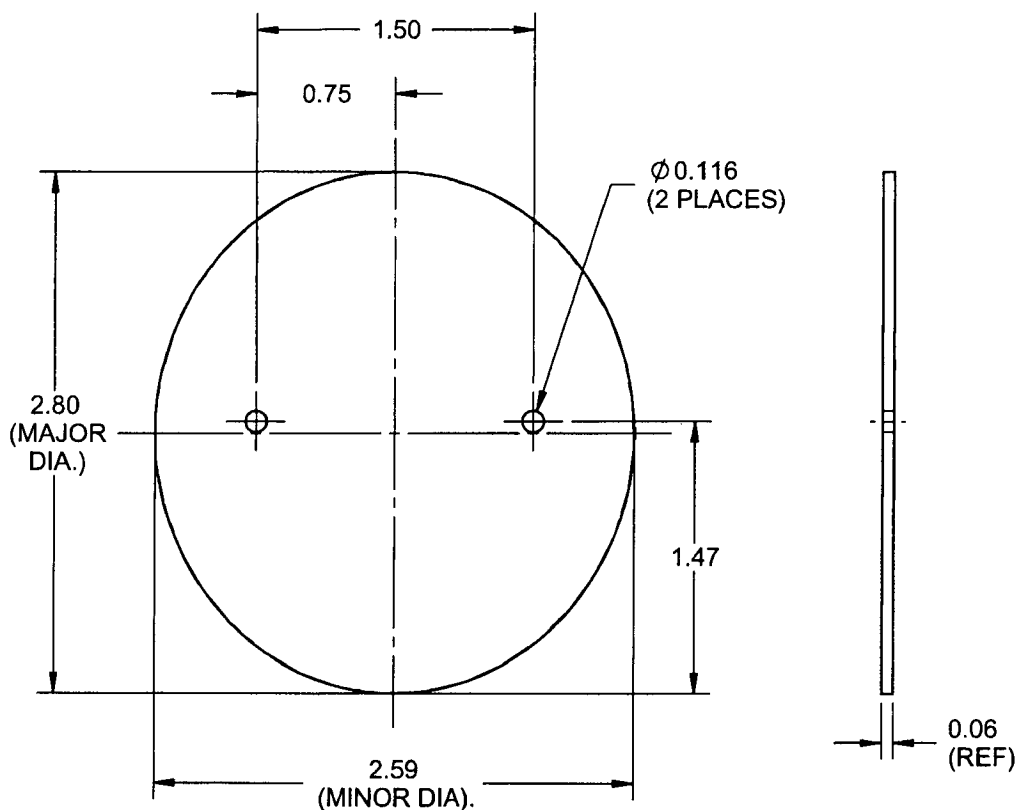
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DATE 06.01.23		TITLE INLET VALVE SHAFT	SCALE 1:1

*[Signature]* 06.04.03



### D3474-7 BUTTERFLY VALVE SEAL

#### NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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